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<p>(21) International File Number: PCT/EP99/09061</p> <p>(22) International Filing Date: November 24, 1999 (11/24/99)</p> <p>(30) Priority Dates: 198 54 843.5 November 27, 1998 (11/27/98) DE</p> <p>(71) Applicant and Inventor: KIRKWOOD INDUSTRIES GMBH [DE/DE]; Schiessmauer 9, D-71083 Herrenberg (DE).</p> <p>(72) Inventor; and</p> <p>(75) Inventor/Applicant (for US only); WAGNER, Armin [DE/DE]; Am Reipersberg 2, D-74420 Oberrot (DE). WISINGER, Claudia [DE/DE]; Schopenhauerstrasse 97, D-80809 Munich (DE), ROTH, Dieter, Michael [DE/DE]; Hildirzhauser Strasse 31, D-71116 Gärtringen-Rohrau (DE), EIGNER, Michael [DE/DE]; Kelterrainsstrasse 39, D-70771 Leinfelden-Echterdingen (DE), KÖNIG, Eckhard [DE/DE]; Königsberger Strasse 29, D-71139 Ehningen (DE).</p> <p>(74) Representative: BARTELS & PARTNERS; Lange Strasse 51, D-70174 Stuttgart (DE).</p>	<p>(81) Contracting states: JP, SI, US, European Patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).</p> <p>Published <i>With international search report.</i></p>																									
<p>(54) Title: COMMUTATION DEVICE, ESPECIALLY A COMMUTATOR, AND A METHOD FOR PRODUCING SUCH A DEVICE</p> <p>(57) Abstract:</p> <p>The aim of the invention is to provide a commutator that has extremely exact geometrical dimensions, a long-time stability and is easy to produce. To this end, a commutator (1; 101; 201) with a pre-shaped, substantially cylindrical support body (3; 103; 203; 303) is provided which has a rotational axis (2; 102; 202; 302). Said commutator also has electrically conductive commutator segments (4; 104; 204; 304) which can be fixated on the support body (3; 103; 203; 303) by fasteners (5; 105; 205; 305) which are arranged substantially between the commutator and the segments (4; 104; 204; 304). The inventive commutator is further characterized in that the support body (3; 103; 203; 303) and the segments (4; 104; 204; 304) are provided with means (3', 3", 4", 4a'; 106, 107; 309, 311) which interact to position and adjust the segments (4; 104; 204; 304) relative to the support body (3; 103; 203; 303).</p> <table border="0"> <tr> <td>1</td> <td>Shaping a support body</td> </tr> <tr> <td>2</td> <td>Shaping the segments</td> </tr> <tr> <td>3</td> <td>Applying bonding agent</td> </tr> <tr> <td>4</td> <td>Contacting the segments with the support body</td> </tr> <tr> <td></td> <td>- subsequently or</td> </tr> <tr> <td></td> <td>- simultaneously</td> </tr> <tr> <td>5</td> <td>Adjusting and positioning</td> </tr> <tr> <td>6</td> <td>Fixating the segments by</td> </tr> <tr> <td></td> <td>- jamming and/or</td> </tr> <tr> <td></td> <td>- bonding</td> </tr> <tr> <td></td> <td>- soldering or</td> </tr> <tr> <td></td> <td>- welding</td> </tr> </table>			1	Shaping a support body	2	Shaping the segments	3	Applying bonding agent	4	Contacting the segments with the support body		- subsequently or		- simultaneously	5	Adjusting and positioning	6	Fixating the segments by		- jamming and/or		- bonding		- soldering or		- welding
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